

Work Order ID 73844

Friday, September 16, 2011 12:36:15 PM



Page 1

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop



Start Date: 9/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

B.A 11/11/21

HAAS 1

Memo

0.00

FK 11/11/22

7

0

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11/11/21 by B.A. ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

FK 11/11/22

Mill Conv

Memo

0.00

7

0

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

FK 11/11/22

QC

Memo

0.00

7

0

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 73844

Friday, September 16, 2011 12:36:15 PM



Page 2

| | | | | | | |
|----------------|----------------------------|------------|-------|-------|---------------|--|
| Item ID: | D2661-2 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Saddle, RH Fwd Aft Out 206 | | | | | |
| Start Date: | 9/16/2011 | Start Qty: | 10.00 | | Cust Item ID: | |
| Required Date: | 10/28/2011 | Req'd Qty: | 10.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|----------------------|--------------|---------------|---------------|--------------------|----------------|
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | <i>only 11/11/23</i> | | <i>7</i> | <i>10</i> | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | <i>7</i> | | <i>BL 11-11-24</i> | |
| 150 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo | 0.00 0.00 | | | | | | | |

START TIME: *8:00* OVEN TEMPERATURE:
FINISH TIME: *8:30*

3200F

8:30

M118439

TX of M-11/11/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73844

Friday, September 16, 2011 12:36:15 PM



Page 3

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BR 11-11-29

170

Identify as per dwg & Stock Location 435

0.00



Packaging

Memo

0.00

Packaging

11/11/30 70

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/11

C Lul 11/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, September 16, 2011 12:36:13 PM

Work Order ID: 73844



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003 | | Manufactured | No | | | 100 | Each | 13.0000 | 1 | 10 | | | |

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

5

72226

5

→ 74650

7.0

B.A 11/11/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2662-1 |
| Inspection Dwg: D2662 Rev. D | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .135 | .135 | .135 | .135 | | |
| B | 0.100 | 0.140 | | .124 | .125 | .125 | .125 | | |
| C | 1.125 | 1.145 | | 1.1340 | 1.1343 | 1.1344 | 1.1351 | | |
| D | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | | |
| E | 0.240 | 0.260 | | .252 | .252 | .253 | .252 | | |
| F | 1.313 | 1.343 | | 1.328 | 1.327 | 1.327 | 1.327 | | |
| G | 0.210 | 0.230 | | .227 | .227 | .227 | .227 | | |
| H | 0.100 | 0.180 | | .135 | .130 | .135 | .135 | | |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | | |
| J | 1.565 | 1.585 | | 1.5735 | 1.5731 | 1.5732 | 1.5734 | | |
| K | 0.235 | 0.240 | | .236 | .236 | .236 | .236 | | |
| L | 0.100 | 0.120 | | .111 | .111 | .111 | .111 | | |
| M | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | | |
| N | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | | |
| O | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.313 | 0.318 | | .314 | .314 | .314 | .314 | | |
| S | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | | |
| V | 0.787 | 0.807 | | .795 | .797 | .797 | .797 | | |
| W | 0.540 | 0.560 | | .549 | .549 | .548 | .550 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | .260 | .260 | .260 | .260 | | |
| Z | 0.912 | 0.932 | | .922 | .921 | .921 | .922 | | |
| AA | 0.490 | 0.510 | | .500 | .499 | .501 | .498 | | |
| AB | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|------------------------|-----------------------|
| Measured by: <u>BA</u> | Audited by: <u>am</u> |
| Date: <u>11/11/21</u> | Date: <u>11/11/23</u> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.11 | Added Dim. R-T | RF | |
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2662-1 |
| Inspection Dwg: D2662 Rev. D | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|--------|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 16 | 17 | 4 | By | Date |
| A | 0.100 | 0.140 | | .135 | .135 | .135 | | | |
| B | 0.100 | 0.140 | | .123 | .123 | .122 | | | |
| C | 1.125 | 1.145 | | 1.1335 | 1.1338 | 1.1333 | | | |
| D | 0.615 | 0.685 | | .680 | .680 | .680 | | | |
| E | 0.240 | 0.260 | | .253 | .253 | .253 | | | |
| F | 1.313 | 1.343 | | 1.325 | 1.325 | 1.325 | | | |
| G | 0.210 | 0.230 | | .226 | .227 | .227 | | | |
| H | 0.100 | 0.180 | | .135 | .135 | .135 | | | |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | | | |
| J | 1.565 | 1.585 | | 1.5743 | 1.5715 | 1.5714 | | | |
| K | 0.235 | 0.240 | | .236 | .236 | .236 | | | |
| L | 0.100 | 0.120 | | .111 | .111 | .111 | | | |
| M | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | | | |
| N | 0.510 | 0.515 | | .512 | .512 | .512 | | | |
| O | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | | | |
| P | 1.245 | 1.255 | | 1.2500 | 1.250 | 1.250 | | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | | | |
| R | 0.313 | 0.318 | | .314 | .314 | .314 | | | |
| S | 0.315 | 0.322 | | .316 | .316 | .316 | | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | | | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | | | |
| V | 0.787 | 0.807 | | .797 | .797 | .797 | | | |
| W | 0.540 | 0.560 | | .549 | .549 | .549 | | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | | | |
| Y | 0.257 | 0.262 | | .260 | .260 | .260 | | | |
| Z | 0.912 | 0.932 | | .922 | .921 | .923 | | | |
| AA | 0.490 | 0.510 | | .498 | .501 | .497 | | | |
| AB | 0.178 | 0.198 | | .188 | .188 | .188 | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

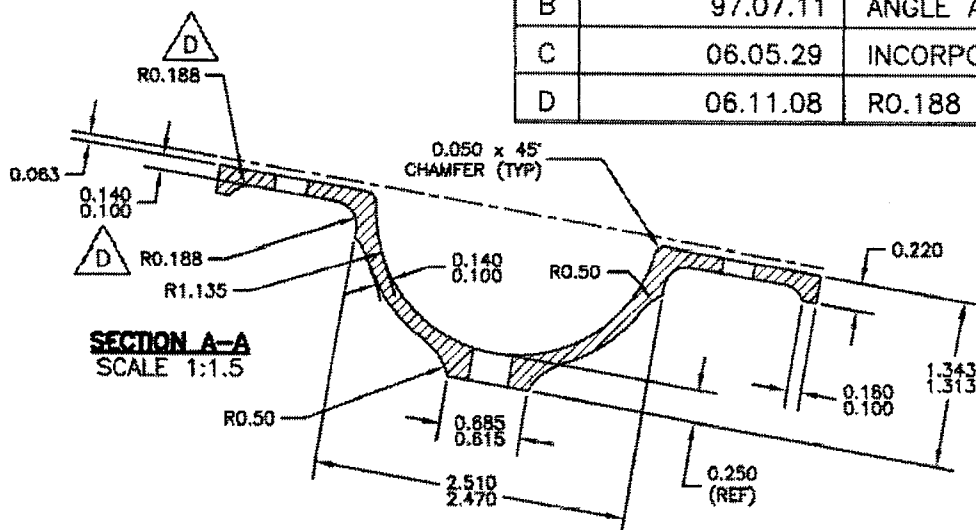
| | |
|--------------|-----------|
| Measured by: | <i>KR</i> |
| Date: | 11/11/23 |

| | |
|-------------|------------|
| Audited by: | <i>amf</i> |
| Date: | 11/11/23 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|--------------------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.11 | Added Dim. R-T | RF | |
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | <i>[Signature]</i> |



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED # | DRAWING NO. D2661 | REV. D SHEET 1 OF 1 |
| DATE 06.11.08 | | TITLE SADDLE OUTSIDE | SCALE 1:3 |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.07.11 | ANGLE AND NOTES ADDED | |
| C | 06.05.29 | INCORPORATE DEO 9122, 9102, 9095 | |
| D | 06.11.08 | R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$ | |

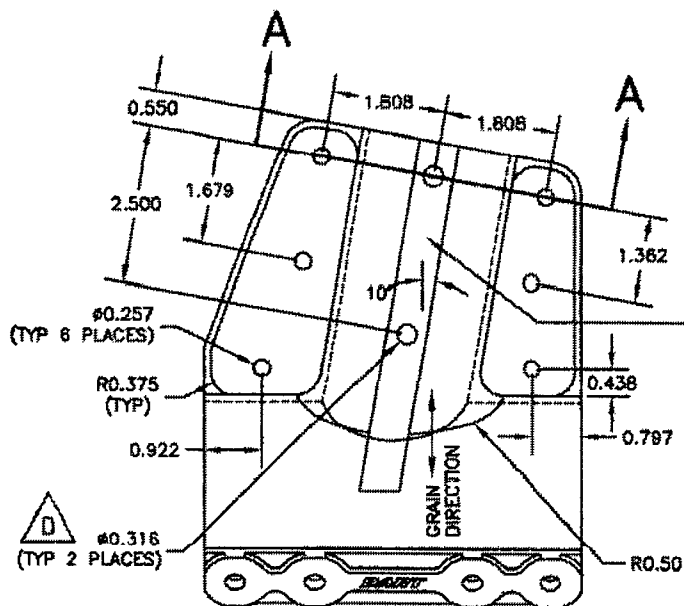


SECTION A-A
SCALE 1:1.5

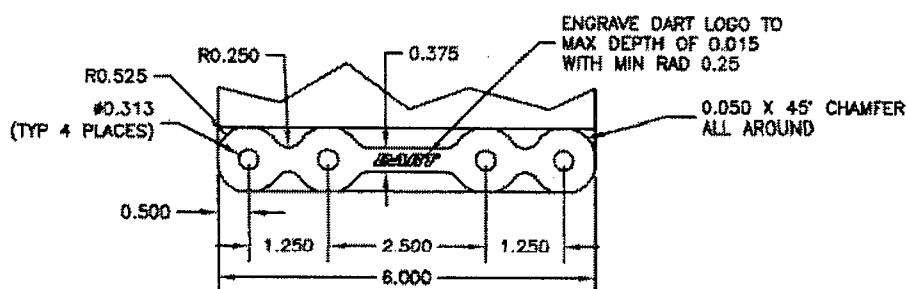
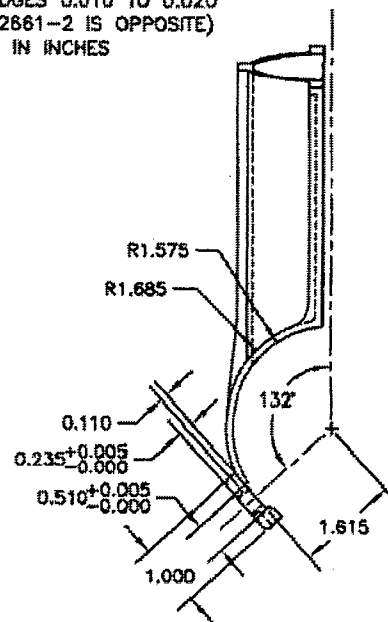
RELEASED
07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2661-1 SADDLE OUTSIDE

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